

Work Order ID 60070



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June 24, 2010 9:01:38 AM

Item ID: D3259-042

Accept



Setup Start



Revision ID:

Stop



Item Name: Access Panel Assembly

Start Date: 6/24/10 Start Qty: 4.00



Cust Item ID:

Required Date: 7/02/10 Req'd Qty: 4.00

Customer:

Reference:

Run Start



Approvals: Process Plan: *W*

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3259	Rev B								
100	Pick Kit	0.00							
Packaging	Memo	0.00							
Packaging									
110	Small Fab	0.00							
Small Fab	Memo	0.00							
Small Fab	Assemble D3259-041 as per Dwg D3259 . □Note:Keep .040" Gap all around door.								
120	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

EB 10/07/09 (4)

EB 10/07/09 (4)

S 10/07/09

(4)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 60070

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Page 2

Item ID: D3259-042

Accept

Setup Start

Revision ID:

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Item Name: Access Panel Assembly

Start Date: 6/24/10

Start Qty: 4.00

Cust Item ID:

Required Date: 7/02/10

Req'd Qty: 4.00

Customer:

Reference:

Run Start

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: 1E2

0.00



Packaging

Memo

0.00

Packaging

10-7-9

SP (4/12)

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

MF 10-7-9

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 60070

Parent Item: D3259-042

Parent Item Name: Access Panel Assembly



Start Date: 6/24/10

Required Date: 7/02/10

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 07-07-19 JLM Verified By:EC
B:AS PER REV B 10-05-19 JLM VERIFIED BY:EC IPP REV

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3161-5

Manufactured

No

110

Each

17.0000

1

4



Hinge 9.9"

Location

Loc Qty

Loc Code

ST040

17

43606

2

47187

3

47773

12

D3259-1

Manufactured

No

110

Each

5.0000

1

4



Panel

Location

Loc Qty

Loc Code

ST180

5

58749

5

D3259-4

Manufactured

No

110

Each

0.0000

1

4



Doubler

D3259-5

Manufactured

No

110

Each

4.0000

1

4



Spacer

Location

Loc Qty

Loc Code

ST180

4

58750

4

EPB 10/07/09

EPB 10/07/09

B60086 (4x) EPB 10/07/09

EPB 10/07/09

4

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

June 24, 2010 9:01:36 AM

Page 2 / 3

Work Order ID: 60070

Parent Item: D3259-042

Parent Item Name: Access Panel Assembly



Start Date: 6/24/10

Required Date: 7/02/10

Start Qty: 4.00

Required Qty: 4:00

D3259-7



Door

Manufactured No

110 Each 7.0000



4
EP 50/07/09

Location

Loc Qty

Loc Code

ST180

7

58751

7

D3260-1



Spring

Manufactured No

110 Each 6.0000



4
8
EP 50/07/09
B60087 (24)

Location

Loc Qty

Loc Code

ST047

6

47852

6

D3972-5



Grommet, Half, DZUS

Manufactured No

110 Each 11.0000



6
8
EP 50/07/09
M12495 (82)

Location

Loc Qty

Loc Code

ST107

11

58752

11

D3973-5



Receptable, Rigid, DZUS

Manufactured No

110 Each 84.0000



8
EP 10/07/09

Location

Loc Qty

Loc Code

ST107

84

58759

84

D3974-20



Stud, Wing Head, 5/16 DZUS

Manufactured No

110 Each 90.0000



8
8
EP 10/07/09
88

Location

Loc Qty

Loc Code

ST107

90

58761

90

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

June 24, 2010 9:01:36 AM

Page 3

Work Order ID: 60070

Parent Item: D3259-042

Parent Item Name: Access Panel Assembly



Start Date: 6/24/10

Required Date: 7/02/10

Start Qty: 4.00

Required Qty: 4.00

MS20426AD4-4

Purchased

No

110

Each

1,249.000

4



Rivet

Location

Loc Qty

Loc Code

ST316

1249

15541

1249

110

Each

11,008.00

36

MS20470AD3-4

Purchased

No



Rivet, Universal Head

Location

Loc Qty

Loc Code

ST319

11008

111477

8332

15541

2676

100

Each

4,282.000

10

MS20470AD3-5

Purchased

No



Rivet

Location

Loc Qty

Loc Code

ST319

4282

104817

3030

9682

1252

16
E 50/07/09

16
144
E 50/07/09

144
40
E 50/07/09

40

June 24, 2010 9:01:36 AM

Shop Packet Print

Page 3

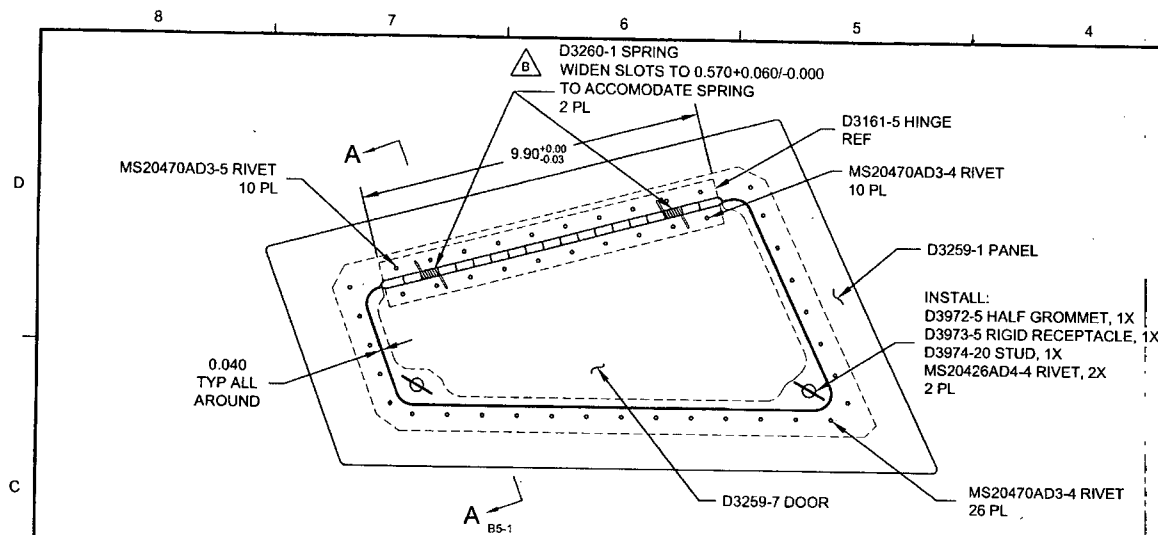
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

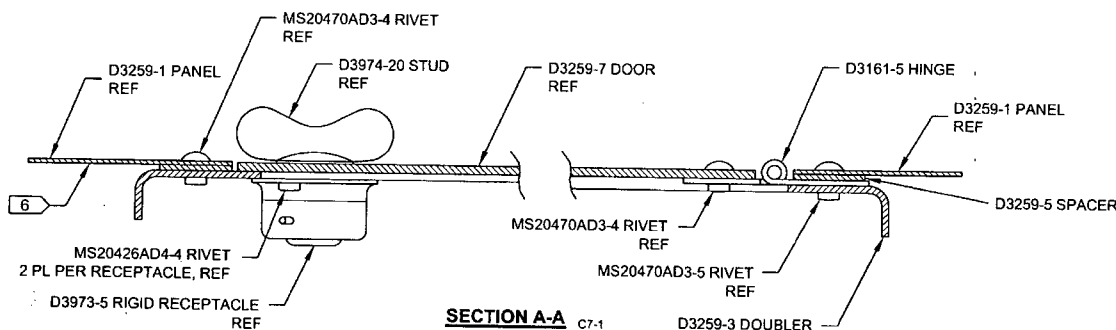
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



ITEM	QTY	PART NUMBER	DESCRIPTION
1	X	D3259-041	ACCESS PANEL ASSEMBLY
2	1	D3161-5	HINGE
3	1	D3259-1	PANEL
4	1	D3259-3	DOUBLER
5	1	D3259-5	SPACER
6	1	D3259-7	DOOR
7	2	D3260-1	SPRING
8	2	D3972-5	GROMMET, HALF, DZUS
9	2	D3973-5	RECEPTACLE, RIGID, DZUS
10	2	D3974-20	STUD, WING HEAD, 5/16 DZUS
11	36	MS20470AD3-4	RIVET
12	10	MS20470AD3-5	RIVET
13	4	MS20426AD4-4	RIVET



SECTION A-A
VIEW ROTATED
NOT TO SCALE

D3259-041 ACCESS PANEL ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: IDENTIFY WITH P/N "D3259-041" AND B/N "BXXXXX" USING FINE POINT PERMANENT MARKER
- 7) WEIGHT: 1.2 lbs

RELEASED
2009-10-08

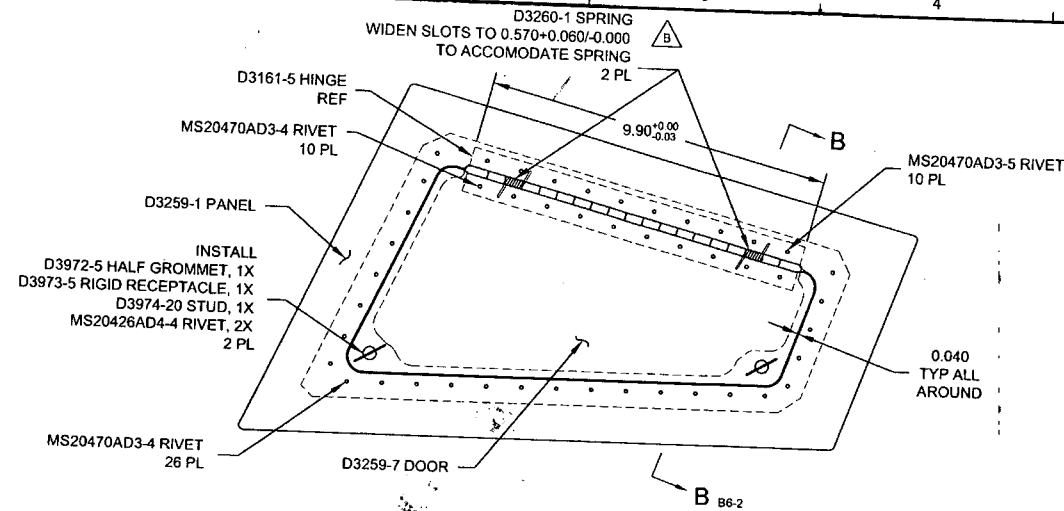
REV.	DESCRIPTION	BY	DATE
B	REFORMAT DWG, R0.25 WAS R0.18 (ZN B8-4, B1-5) -3F REDESIGN (SHT 6), WIDEN SLOTS (ZN D6-1, D5-2)	CP	09.08.12
A	NEW ISSUE	CP	04.02.25
DESIGN	RF		
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.08.12		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

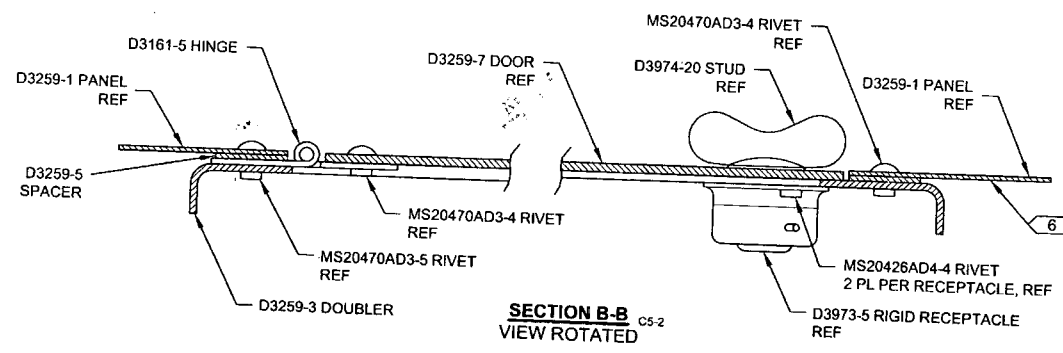
DRAWING NO. D3259
REV. B
SHEET 1 OF 8
TITLE
ACCESS PANEL ASSEMBLY
SCALE
NTS

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8 7 6 5 4 3 2 1



ITEM	QTY	PART NUMBER	DESCRIPTION
1	X	D3259-042	ACCESS PANEL ASSEMBLY
2	1	D3161-5	HINGE
3	1	D3259-1	PANEL
4	1	D3259-4	DOUBLER
5	1	D3259-5	SPACER
6	1	D3259-7	DOOR
7	2	D3260-1	SPRING
8	2	D3972-5	GROMMET, HALF
9	2	D3973-5	RECEPTACLE, RIGID, DZUS
10	2	D3974-20	STUD, WING HEAD, 5/16 DZUS
11	36	MS20470AD3-4	RIVET
12	10	MS20470AD3-5	RIVET
13	4	MS20426AD4-4	RIVET



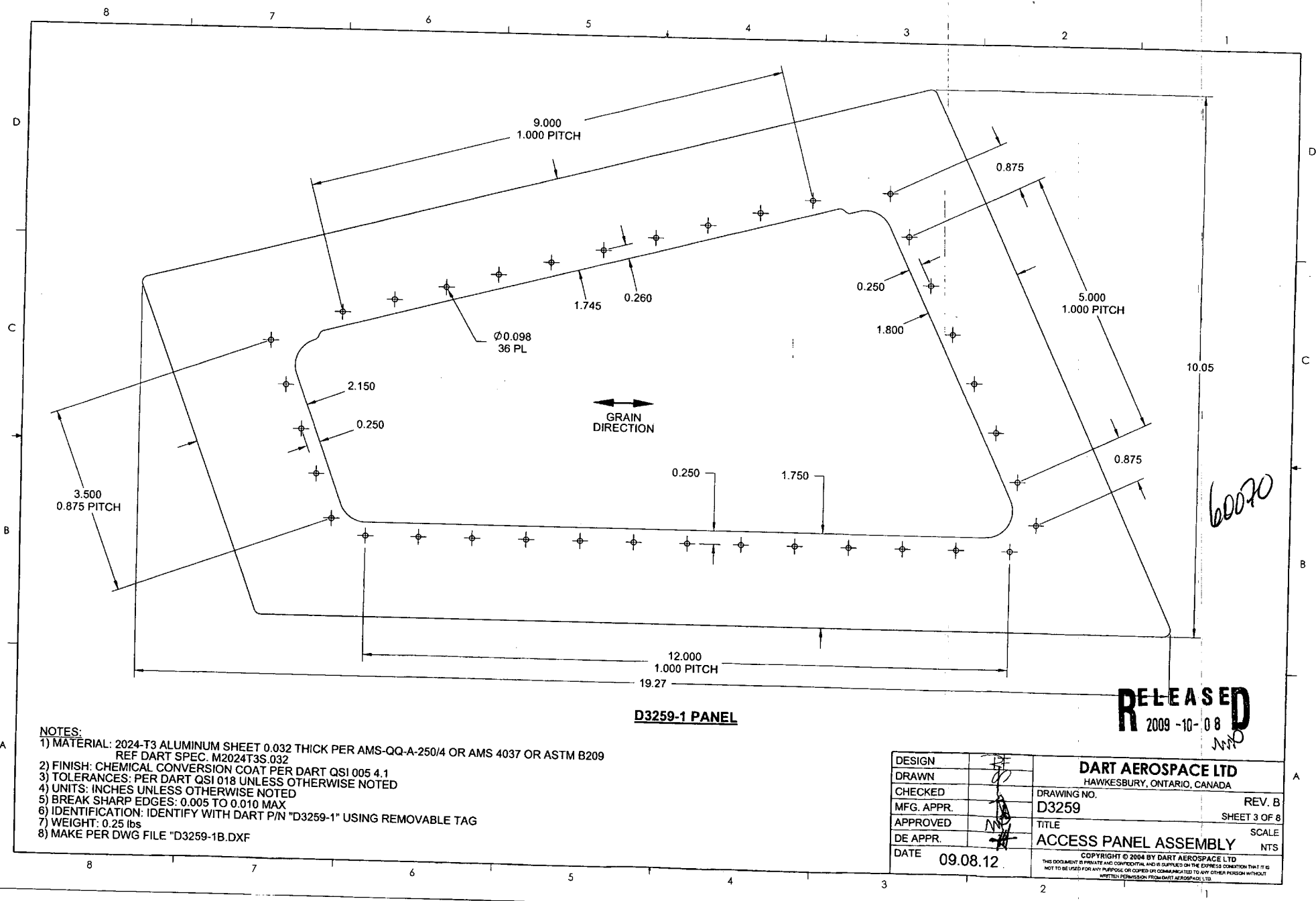
D3259-042 ACCESS PANEL ASSEMBLY

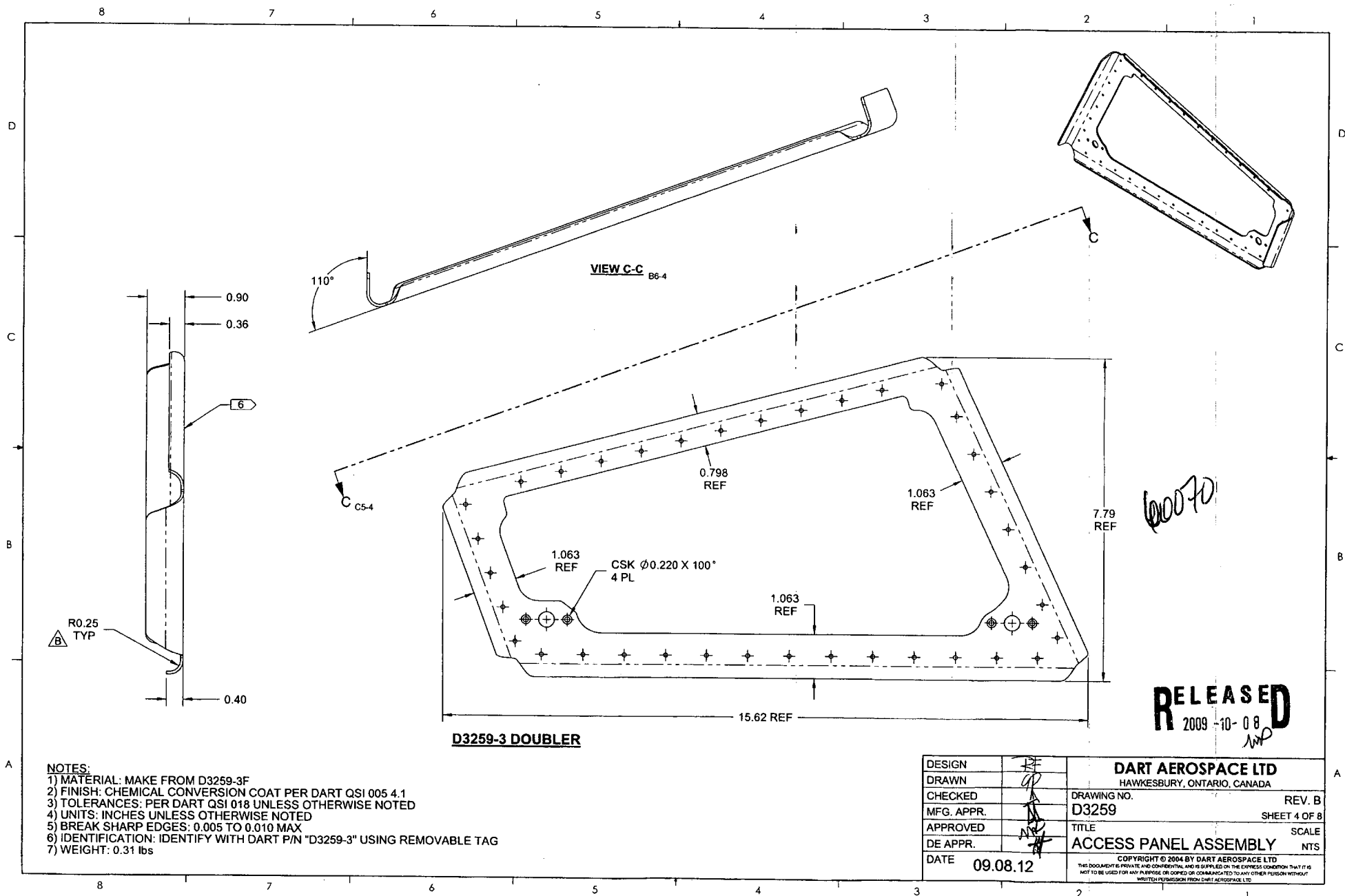
- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: NONE
 - 6) IDENTIFICATION: IDENTIFY WITH P/N "D3259-042" AND B/N "BXXXXX" USING FINE POINT PERMANENT MARKER
 - 7) WEIGHT: 1.2 lbs

RELEASED
2009-10-08
MD

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO.	REV. B
CHECKED		D3259	SHEET 2 OF 8
MFG. APPR.		TITLE	SCALE
APPROVED		ACCESS PANEL ASSEMBLY	NTS
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DATE	09.08.12		

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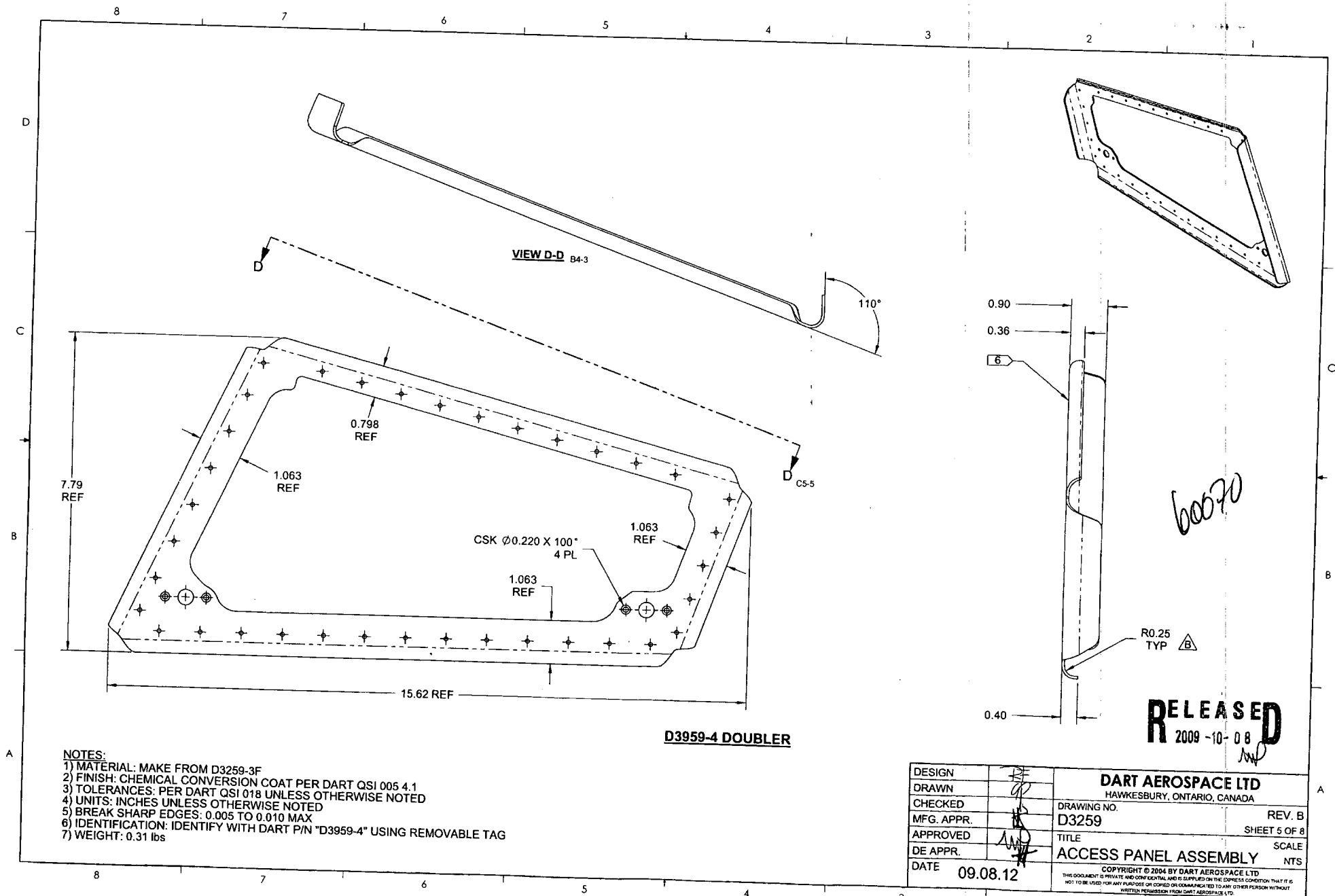


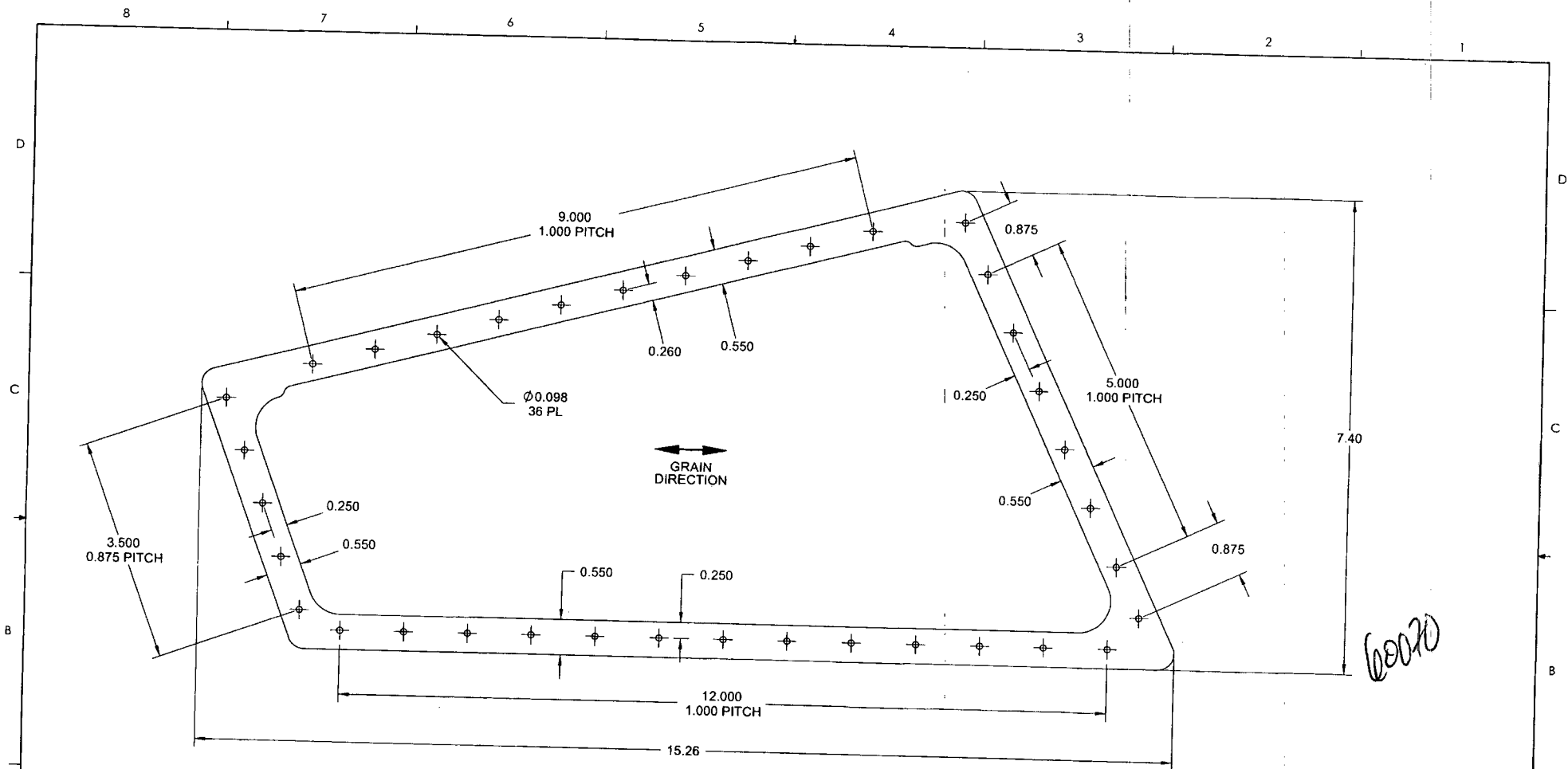


60070

RELEASED
2009-10-08
AMP

DESIGN	FE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	GP		
CHECKED	AS	DRAWING NO.	REV. B
MFG. APPR.	AS	D3259	SHEET 4 OF 8
APPROVED	NY	TITLE	SCALE
DE APPR.	NY	ACCESS PANEL ASSEMBLY	NTS
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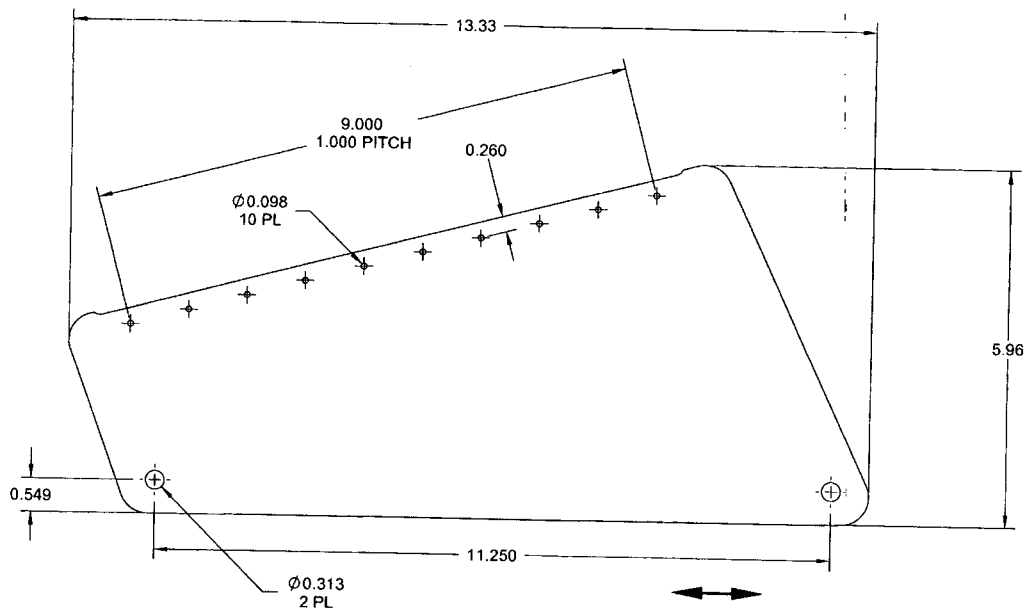
D3259-5 SPACER

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.032 THICK PER AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209
REF DART SPEC. M2024T3S.032
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3259-5" USING REMOVABLE TAG
- 7) WEIGHT: 0.07 lbs
- 8) MAKE PER DWG FILE "D3259-5B.DXF"

RELEASED
2009-10-08

DESIGN	PF	DART AEROSPACE LTD	
DRAWN	GP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JS	DRAWING NO.	REV. B
MFG. APPR.	JS	D3259	SHEET 7 OF 8
APPROVED	JS	TITLE	SCALE
DE APPR.	JS	ACCESS PANEL ASSEMBLY	NTS
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D3259-7 DOOR

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.063 THICK PER AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209
REF DART SPEC. M2024T3S.063
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3259-7" USING REMOVABLE TAG
- 7) WEIGHT: 0.35 lbs
- 8) MAKE PER DWG FILE "D3259-7B.DXF"

RELEASED
2009-10-08

DESIGN	7	DART AEROSPACE LTD	
DRAWN	7	HAWKESBURY, ONTARIO, CANADA	
CHECKED	7	DRAWING NO.	REV. 8
MFG. APPR.	7	D3259	SHEET 8 OF 8
APPROVED	7	TITLE	SCALE
DE APPR.	7	ACCESS PANEL ASSEMBLY	NTS
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